

Date: Monday, 16/06/2008 10:25:22 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: LUG BRACKET		
Job Number	: 39885			Part Number	: D27351		
Estimate Number	: 10009			Drawing Number	: D2735 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 16/06/2008 S.O. No. :			Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 30/06/2008 Qty: 60 Um: Each		
Previous Run	: 39819			JLM			
Written By	:			EC			
Checked & Approved By	: JUL 08. le. 11p						
Comment	: Est Rev:C Removed from 9 Digit 05-10-25 est rev D waterjet 06.09.19						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S125	1010-1025 sheet .125 Comment: Qty.: 0.1733 sf(s)/Unit Total : 10.3950 sf(s) 1010-1025 sheet .125 batch: 108336 HB 8-7-3
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D2735 (D2735-1) Dwg Rev: C Prog Rev: C HB 8-7-3 2-Deburr if necessary. HB 8-7-3
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 8-7-3
4.0	QC8	SECOND CHECK Comment: SECOND CHECK HB 8-7-3
5.0	BRAKE NC	NC BRAKE Comment: NC BRAKE 1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204 2-Deburr if required. HB 8-7-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

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Part Number: D27351

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Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



center

508/07/15 (x66)

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



x66

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 267

8/1/15

sy

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/16 88

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39885
Description: Lug Bracket	Part Number:	D2735-1
Inspection Dwg: D2735	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

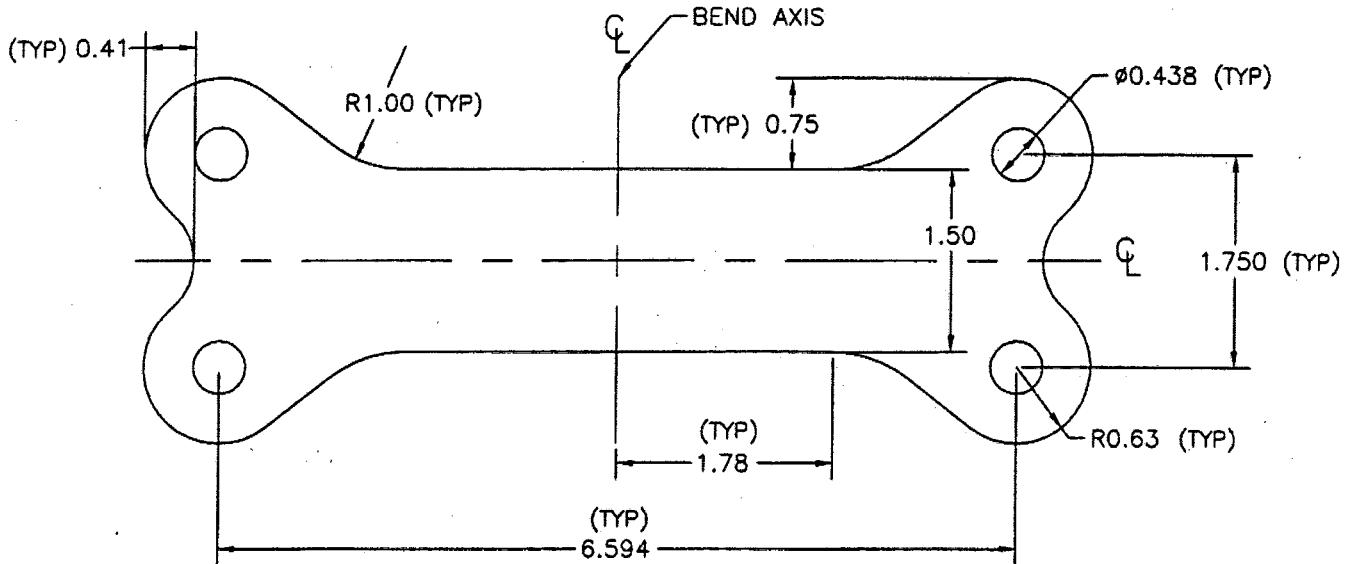
X First Article Prototype

Measured by: <u>D</u>	Audited by: <u>D</u>	Prototype Approval: N/A
Date: <u>9-7-3</u>	Date: <u>08/02/04</u>	Date: N/A

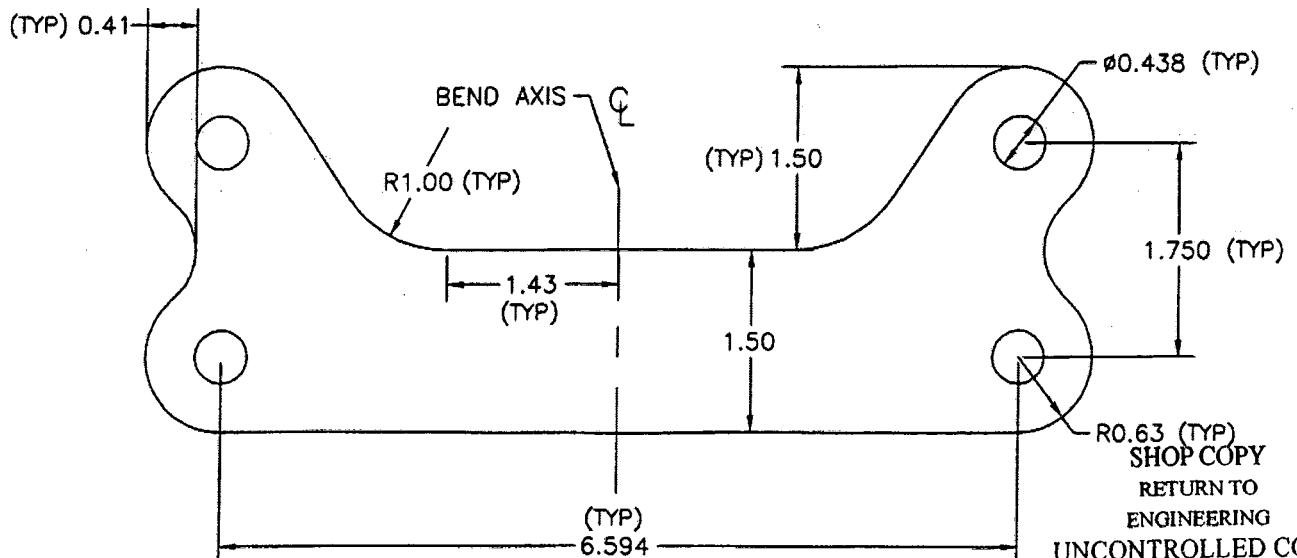
Rev	Date	Change	Revised by	Approved
A	07.02.02	New Issue	KJ/JLM	SM

DARTCOPY IS
MADE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
CP	KE	D2735	SHEET 1 OF 2
DATE		TITLE	SCALE
98.12.14		LUG BRACKET	2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED
98.12.14 DS

D2735-1 FLAT PATTERN
SYMMETRIC ABOUT BOTH CENTRE-LINES (C)

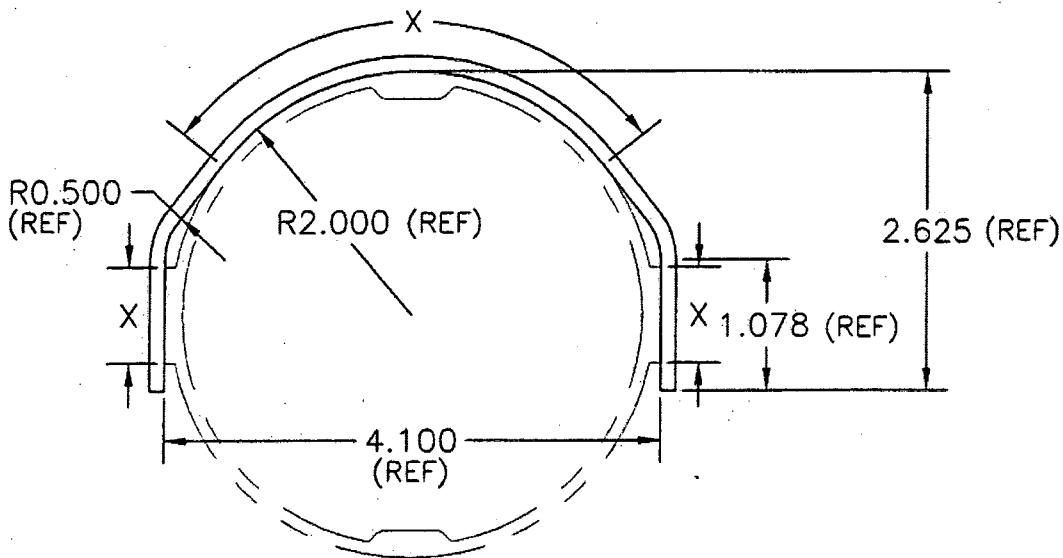


D2735-3 FLAT PATTERN
SYMMETRIC ABOUT CENTRE-LINE (C)



DESIGN <i>PF</i>	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

RELEASED
18.12.14 DS



D2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.125 THICK (11 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39885